



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2574

Job Sheet 179627



Part No: D2574

Job Qty: 8 ea

Part Name: Saddle, Aft, In



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F IPP Rev: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		7/6/18	0.00	0.00	Start Up Machining		SBL 18/07/23
100	CNC Vertical Machining	8 pcs		7/6/18	1.21	12.50	HAAS 1		SBL 18/07/26
110	Mill Conv	8 pcs		7/6/18	0.00	1.00	Mill Conv 1		SBL 18/07/26
120	QC	8 pcs		7/6/18	0.00	0.00	QC2		SBL 18/07/26
130	QC	8 pcs		7/6/18	0.00	0.00	QC8		mm 18/07/26
140	HandFinish	8 pcs		7/6/18	0.00	0.32	HandFinish1		SA 18-07-30
150	Powdercoat	8 pcs		7/6/18	0.00	0.26	Powdercoat1		ML 18-7-3
160	QC	8 pcs		7/6/18	0.00	0.00	QC3		38
170	Packaging	8 pcs		7/6/18	0.00	0.00	Packaging3		21 AUG 09 2018
180	QC21-SA	8 Ea		7/6/18	0.00	0.00	QC21		21 AUG 09 2018

Part Op 100 - Program Batch No. SC95202 Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
Descriptions: 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
110 - Machine keyway as per dwg D2573 & D2574
150 - START TIME: 10:45AM FINISH TIME: 11:15AM 320°F

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	8 Ea (1 ea)	90-Start up Operation	SC95202 SC95195

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	8	54	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Inboard	0.438Inches	+ 0.005 - 0.000	0.443 0.438	
2	Saddle, Aft Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	
3	Saddle, Aft Inboard	3.495Inches	+ 0.010 - 0.000	3.505 3.495	
4	Saddle, Aft Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	

5	Saddle, Aft Inboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Aft Inboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Aft Inboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Aft Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Aft Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Inboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Inboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Inboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Aft Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Inboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

DART AEROSPACE LTD	Work Order: 179 627
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.75	1.75	1.750	1.750		
C	3.495	3.505		3.5	3.50	3.50	3.50		
D	1.745	1.755		1.75	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.004	8.004		
F	0.490	0.510		0.503	0.501	0.502	0.505		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.501	0.501	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570	0.569	0.568	0.5685		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.130	0.130	0.130		
Q	0.115	0.135		0.124	0.124	0.125	0.125		
R	0.240	0.260		0.251	0.251	0.251	0.251		
S	0.115	0.135		0.125	0.125	0.125	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.23	3.23	3.23		
V	0.230	0.250		0.240	0.240	0.247	0.240		
W	0.115	0.135		0.134	0.134	0.134	0.133		
X	0.307	0.312		0.312	0.312	0.312	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.364	0.364	0.363		
AA	0.470	0.530		0.500	0.500	0.5	0.5		
AB	0.615	0.635		0.624	0.625	0.623	0.625		
AC	0.053	0.073		0.060	0.060	0.06	0.06		
AD	0.240	0.260		0.250	0.250	0.248	0.248		
AE	1.500	1.520		1.510	1.510	1.51	1.51		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.250	0.250	0.25	0.250		
AH	0.240	0.260		0.250	0.252	0.253	0.253		
AI	2.000	2.020		2.000	2.000	2.0	2.0		
AJ	0.023	0.043		0.033	0.33	0.033	0.033		
Accept/Reject									

Measured by: DAS	
Date: 57 18/07/20	
9-89	

Audited by: [Signature]	
Date: 18/07/20	

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 179627
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	27	48		
A	0.438	0.443	/	0.438	0.438	0.438	0.438		
B	1.745	1.755	/	1.75	1.745	1.745	1.745		
C	3.495	3.505	/	3.50	3.5	3.50	3.50		
D	1.745	1.755	/	1.75	1.75	1.75	1.75		
E	7.990	8.010		8.001	8.002	8.002	8.002		
F	0.490	0.510		0.500	0.498	0.498	0.500		
G	0.257	0.262	/	0.257	0.257	0.257	0.257		
H	0.375	0.380	/	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.5005	0.500	0.500		
J	1.174	1.184	/	1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570	0.571	0.569	0.569		
L	1.174	1.184	/	1.179	1.179	1.179	1.179		
M	1.365	1.375	/	1.37	1.37	1.37	1.37		
N	2.495	2.505	/	2.50	2.50	2.50	2.50		
O	4.119	4.129	/	4.129	4.129	4.129	4.129		
P	0.115	0.135		0.130	0.130	0.130	0.133		
Q	0.115	0.135		0.124	0.124	0.124	0.124		
R	0.240	0.260	/	0.252	0.252	0.252	0.252		
S	0.115	0.135		0.125	0.125	0.125	0.126		
T	0.178	0.198	/	0.188	0.188	0.188	0.188		
U	3.210	3.250	/	3.23	3.23	3.23	3.23		
V	0.230	0.250		0.238	0.238	0.240	0.240		
W	0.115	0.135		0.132	0.133	0.133	0.133		
X	0.307	0.312		0.312	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.365	0.363	0.364		
AA	0.470	0.530	/	0.50	0.50	0.50	0.50		
AB	0.615	0.635		0.625	0.623	0.624	0.625		
AC	0.053	0.073	/	0.060	0.06	0.06	0.06		
AD	0.240	0.260	/	0.250	0.25	0.25	0.250		
AE	1.500	1.520	/	1.51	1.51	1.51	1.51		
AF	0.115	0.135		0.135	0.135	0.133	0.133		
AG	0.240	0.280	/	0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.252	0.252	0.252	0.252		
AI	2.000	2.020	/	2.00	2.00	2.00	2.00		
AJ	0.023	0.043	/	0.033	0.033	0.033	0.033		

Accept/Reject

DAS

Measured by:	57
Date:	9-89 18/07/20

Audited by:	argus
Date:	18/07/70

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	